

Work Order ID 128101

Wednesday, January 07, 2015 1:29:30 PM

128101

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Item ID: D350-607-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket™ (Fits LH or RH)
 Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference: ECN 14-635

Approvals: Process Plan: mf Date: 15-01-07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								
DSI9709	A								

180 0.00

180

Packaging

Packaging

Memo

PULL FROM STOCK D350-607-041 X 1 ~~128101~~

ADD AN4-15A X 4

PER ECN 14-635

ID AND STOCK UNDER ORIGINAL BATCH NUMBER

ADD DSI PAPERWORK

DAS

26

9-89

JAN 26 2015

195

195

QC

Quality Control

Memo

0.00

0.00

QC4- 100% Inspect kits for completeness

DAS

46

9-89

(1x)

JAN 26 2015

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Quality Control

MLS

1501-26

MF

15-1-26

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D350-607-041

Required Date: 1/6/2015

Required Qty: 1.00

IPP Rev:M 05.09.02 Added D2856-400-720KJ/JLM
 IPP Rev:N 07-12-21 ECN1068 DD IPP Rev:O as
 per ECN10-545 DD 10.04.16 verified by:EC IPP REV:P 12.07.24 AS
 PER ECN 12-603 DD VEF:EC IPP REV:Q 13.08.07 AS PER IIN
 REV.A DD VEF:JLM IPP REV:R 15.01.06 AS PER
 DS19709REV.A DD VEF:JLM

[illegible]

121417 MF
15-01-07

List Lots

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Criteria : Item ID: d350-607-041 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		

D350-607-041	Main Warehouse	121417	10/9/2014	1.0000	QC21	CHG009	
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Heli-Utility-Basket™ (Fits LH or RH)	BSKT						
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Total:				1.0000			
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#128101

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Pressure/Forced
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Over/Under tolerance
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Incorrect
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Part Moved
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Power Loss/Surge
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Wrong Stock Pulled
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Other
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	

5.0 PARTS LIST

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	1						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1							8	8	D2274	RADIUS BLOCK
2					4	4			D2873-043	RADIUS BLOCK
3						1			D5122-1	CENTER SUPPORT
4						6			D5123-1	CLAMP CUSHION
5					4				D5123-3	CLAMP CUSHION
6						2			D5123-5	CLAMP CUSHION
7					2				D5124-1	FWD SUPPORT
8						1			D5134-041	DAMPER SUPPORT ASSY, LH
9						1			D5134-042	DAMPER SUPPORT ASSY, RH
10						1			D5136-1	CONTACT PAD, LH
11						1			D5136-2	CONTACT PAD, RH
12								2	D5149-041	AFT STEP BASE ASSY
13							2		D5149-043	FWD STEP BASE ASSY
14								2	D5150-041	CLAMP ASSEMBLY
15							2		D5150-043	CLAMP ASSEMBLY
16							8		AN4C6A	BOLT
17								8	AN4C12A	BOLT
18					4				MS21920-24	CLAMP
19						6			MS21920-25	CLAMP
20						2			MS21920-28	CLAMP
21	4	4	4	4					AN5C32A	BOLT
22	4	4	4	4					AN5C34A	BOLT
23	12	12	12	12					AN5C7A	BOLT
24	4	4	4	4					MS21043-5	NUT
25	20	20	20	20					NAS1149C0563R	WASHER

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Revision: B

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